

Work Order ID 81736

81736

Page 1

March-19-12 8:46:55 AM

Item ID: D4101-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spring

Start Date: 29/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/19 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4101	B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4101								
Lexan. 1125	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

B/Jm 12/0404 (9)

B/Jm 120404 (9)

(9)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81736

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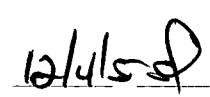
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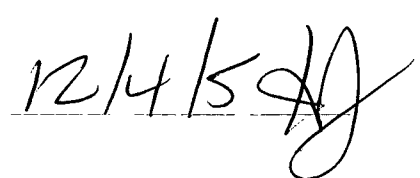
Page 2

Item ID: D4101-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spring
 Start Date: 29/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 02/04/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>125</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/4/5  192

12/4/5 

12-04-5

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Picklist Print

March-19-12 8:46:59 AM

Page 1

Work Order ID: 81736

81736

Parent Item: D4101-5

D4101-5

Parent Item Name: Spring

Start Date: 29/03/2012

Required Date: 02/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.07.07 new issue DD verf:EC
10.09.07 revB DD verf:EC

IPP Rev:A

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,401.612	0.0119	0.0714	0.5		

MI FXS 125-F60029-04

**

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT019

1401.612

119937

1401.612

119937 B / Jm 120404

9

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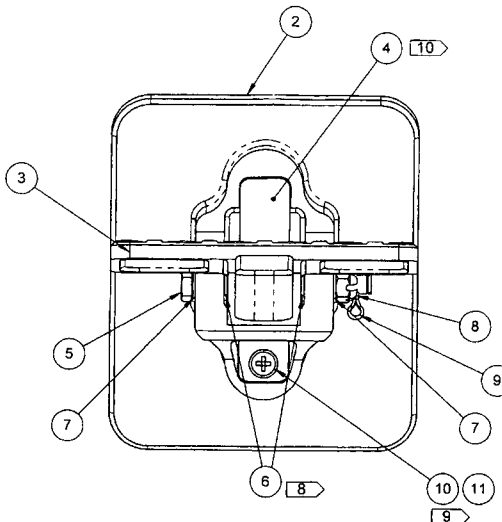
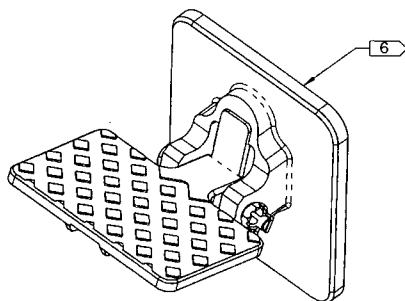
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D4101-041 PRE-FLIGHT STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4101-041" USING FINE POINT PERMANENT INK MARKER BACK SURFACE
- 7) WEIGHT: 1.18 lbs
- 8) INSTALL NAS1149D0432J WASHER IN BETWEEN STEP AND BRACKET MATING FACES
- 9) TORQUE AN525832R SCREW TO 15-25 in-lb
- 10) TEXTURED SIDE TO BOTTOM

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4101-041	PRE-FLIGHT STEP ASSEMBLY
2	1	D4101-1	BRACKET
3	1	D4101-3	STEP
4	1	D4101-5	SPRING
5	1	AN4-22	BOLT
6	2	NAS1149D0432J	WASHER
7	2	NAS1149D0463J	WASHER
8	1	AN310-4	NUT
9	1	MS24665-136	COTTER PIN
10	1	AN525-832R6	SCREW
11	1	MS21209C0815	HELICOIL

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81736 MLCJ
12/03/19

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2010-08-23

B	NAS1149D0432J WAS NAS1149D0416J (ZN D3-1); ADD SCREW AND HELICOIL (ZN D3-1 & B1-3); RE-DESIGN D4101-5 (ZN B4-5)	RF	10.08.05
A	NEW ISSUE	RF	10.07.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4101	SHEET 1 OF 5
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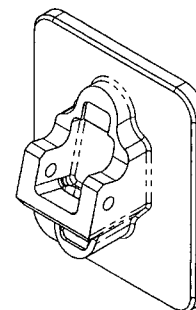
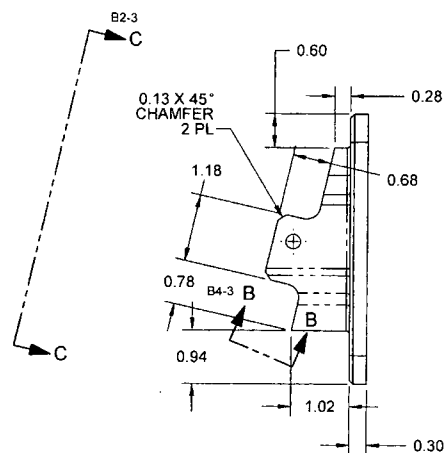
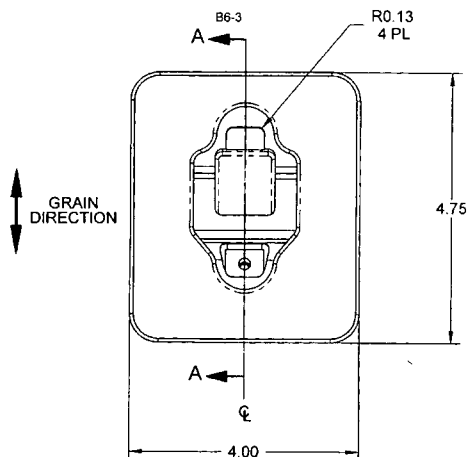
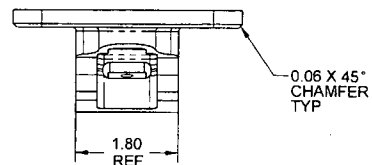
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D4101-1 BRACKET

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2010-08-23

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.85 lbs

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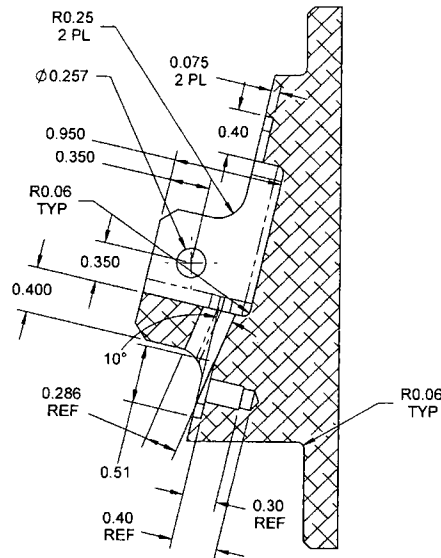
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

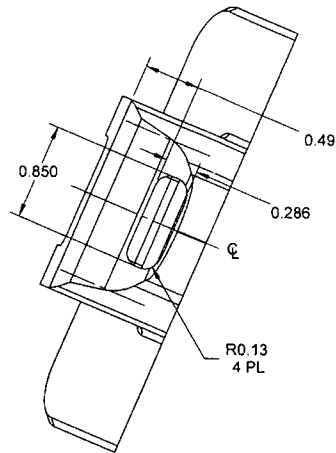
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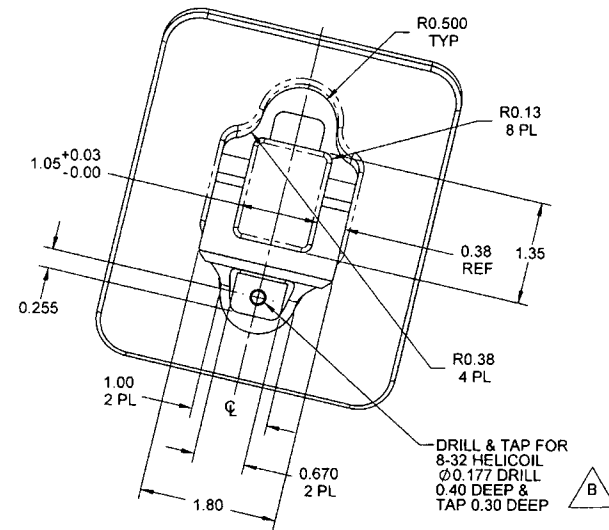
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SECTION A-A C7-2
SCALE 2X



VIEW B-B C4-2
SCALE 2X



VIEW C-C D4-2
SCALE X1.5

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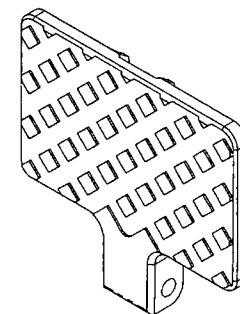
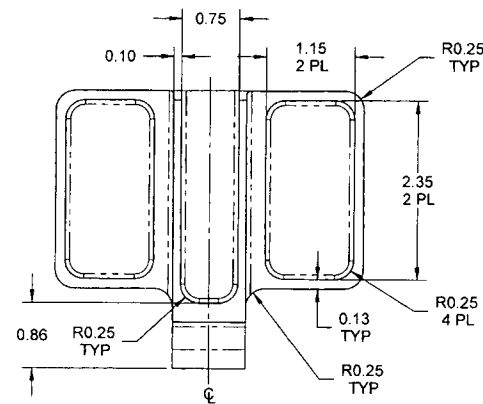
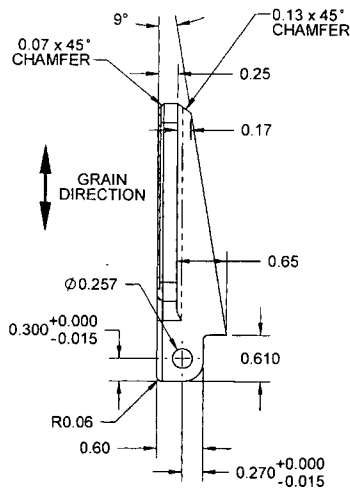
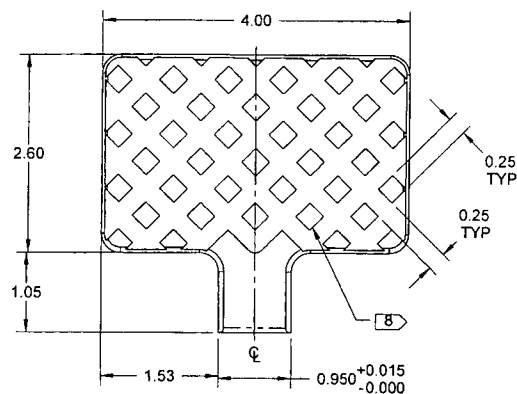
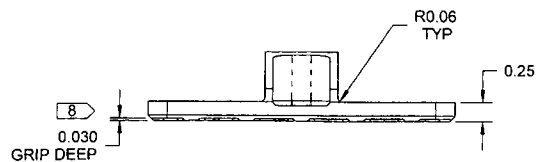
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NOTE: Date & initial all entries



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D4101-3 STEP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) MACHINE 0.25 x 0.25 GRIP 0.030 DEEP AT 45° PATTERN 0.25 APART

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2010-08-23

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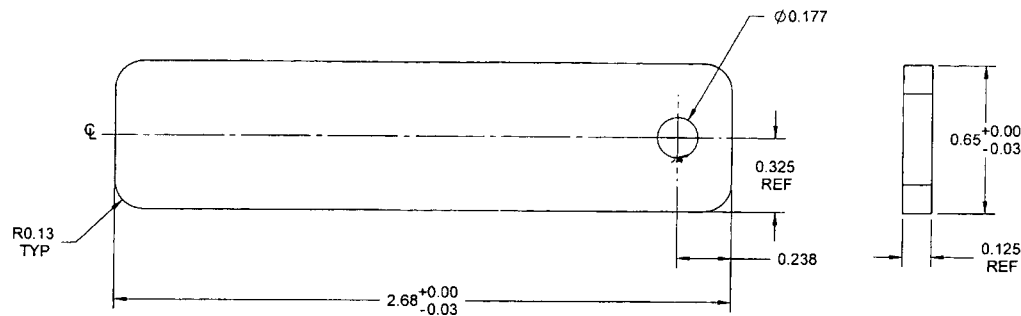
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D4101-5 SPRING

NOTES:

- 1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXX.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

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